

Date: Tuesday, 22/08/2006 7:41:31 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL ASSEMBLY
Job Number	: 25804 -2	Part Number	: D3397041
Estimate Number	: 12100	Drawing Number	: D3397 REV.A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 22/08/2006 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: 09/02/2006 Type : PURCHASED PARTS	Due Date	: 31/03/2006
Previous Run	:	Qty:	3 16 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: est rev. A new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3397041	wheel ass'y
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Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)
wheel ass'y

B25804 (16) M19250 (4)

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting PURCHASING
Issue P/O: 1884
Order Part #4997T28 from McMaster-Carr as per Dwg D3397
Ensure Certificate of Conformity is attached

C206108122

(16)

(PTO)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Ensure certification comply to Dwg D3397

J060825 (16)

10/8/29 (16)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE
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Comment: LARGE FABRICATION RESOURCE 1

1-Remove retainers and bearing from wheel, do not damage retainers, discard bearing. 16+

2-Ship retainers to machining

CPL06-08-26 4+M19250

(25)

5.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
1-Turn as per Dwg D3397

2-Deburr

NOTE: 2 per Assy

06/08/29

19.5

PTC

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 25804

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

IDENTIFY AS D3397-3

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 06/08/29

7.0

D33975

sleeve



Comment: Qty.: 1.0000 (s)/Unit Total: 16.0000 (s)

BZ9906

CPL 07.01.08

(3)

Pick:

Qty Part number Description batch
1 D3397-5 sleeve

BZ6325 B27570

CPL 06.08.29

8.0

HK2820

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

M101988

CPL 07.01.08

(3)

Pick:

Qty Part number Description batch
2 HK2820 bearing

M17496 M101988

CPL 06.08.29

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Assemble bearing, sleeve and retainers as per dwg D3397

CPL 07.01.08

CPL 06.09.06

(3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 07.01.08

(3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

CPL

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ML 07.01.09

(3)

Job Completion



ML 07.01.09


VERDEEN ST
BURY

ON K6A 1

YOUR PURCHASE
ORDER NUMBER
P000001889
Today's Date: 8/22/06

200 AURORA INDUSTRIAL PKWY
AURORA OH 44202
IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT CONTACT OUR SALES DEPARTMENT
(330)995-5500

PAGE
1 OF 1
MCM NUMBER
3046380-01

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
- 21-38	84-694997 T28	16 EA	PNEUMATIC WHEEL WITH BOLTED RIM 12.4" DIA X 3.6"W, 1" AXLE, ROLLER BRNG, 440# CAP 131 RAS 	1	16 EA	16

